Start Qty: 20.00 Req'd Qty: 20.00 n: MLJ Operation Description sion Nbr	*20* *20* Date: 13-03-15	SPC (Y/N): Set Up/	I	ID:			tun	Start Stop Start Stop	*N: *N: *N:	S1* S2* R1*
Req'd Qty: 20.00 n: MLづ Operation Description	*20* Date: 13-03-15	SPC (Y/N): Set Up/	Customer I	: Date:		R			*N	R1*
Operation Description		SPC (Y/N): Set Up/	I			R			*NI	R1*
Description									17	R2*
sion Nbr		Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
!		- William M	F LANCE VERNENNENNENNENNENNENNENNENNENNENNENNENNE							
C										
		0.00 0.00 Prog Rev:	2-			94		EZ	. 13-6	8-28
	achine FAI/FAIB	0.00				44		Œ	13-6	36-
	FLOW WATER JET Memo 1-Cut as per Deburr if nec QC2- Inspect parts off ma	FLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev:_ Deburr if necessary QC2- Inspect parts off machine FAI/FAIB	Memo 1-Cut as per Dwg D2365 Dwg Rev: Prog Rev: C Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 Memo 0.00 0.00 0.00 0.00	O.00 FLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev: Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 Memo 0.00 0.00	Deburr if necessary O.00 -Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-	O.00 Memo O.00 1-Cut as per Dwg D2365 Dwg Rev: Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB O.00 Memo O.00 O.00 O.00 O.00 O.00 O.00 O.00	O.00 FLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB O.00 444 Memo 0.00	PLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 Memo 0.00 YY Memo 0.00	FLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2- Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 444 Memo 0.00	FLOW WATER JET Memo 1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2- Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 44 47 Memo 0.00 47 47 47 47 47 47 47 47 47

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPE	DATE	•		~
	_			***				•			QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	-					Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	No. ـ				<u> </u>	Scrap		1	Machining	Small Fab	1	d. Eng. Coor.	Quality Other
NCR I	No. ₋					Use-as-is Work Order Update		I	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	ı	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling												•	
Operator	Ш												
Material	Ш												
Setup	Ш												
Other													
Process	Ш			·									
Supplier	Ш												
Training													
Unapproved													
						····	AUL	T CATE	GORY				
Landi	$\overline{}$					General		1			1		٦_ ,.
	-	Bending			<u> </u>	Bend		Grain			Ovalized	_	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa		ļ	Over/Under		Temperature/Cure
	\vdash	Cracks				Broken/Damaged	L	4 '	on Incomplete	<u> </u>	Part Incorred		Weld
	$\overline{}$	Crushed/0	Crimped.			Burrs	<u></u>	4	ions Incomplete/L	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved		
		Heat Trea	t		_	Countersink		Mislabe			Positioned V		7
		Inspection	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 98265 March-12-13 1:45:05 PM				*982			Page 2		
Item ID: Revision ID: Item Name:	D2365 Wearplate			Accept	*N900	04010)* s	etup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	3/11/13 3/19/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item II Customer:	D:			
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Da		R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description Chemical Conversion Co	at per QSI005 4.1	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
130 HandFinish Hand Finishing		Memo		0.00			44.	1	JU 13/06/21
140		QC3- Inspect Part Finish		0.00			LUI	1 10	3-6-28.
140 QC Quality Control		Мето		0.00			774	P /3	5-6-28. S
150 *150*		Small Fab		0.00			L/1/N		A. /25/2
Small Fab		Memo Install Insert	as per Dwg D2365	0.00			740		

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	ANCE / UP	DATE		•			
											(QA Closed:	Da	ite:	
Work Ord	or:					DISPOSITION				AGAINST D	ΕP	ARTMENT/	PROCESS		
Work Ord	er. _.					Rework	7		Skid-tube	Crosstube			Water Jet		Engineering
Part I	Vo.					_. Scrap		1	Machining	Small Fab]		d. Eng. Coor.	-	Quality
NCR I	No.	·				Use-as-is Work Order Update	_	4	noforming Large Fab	Finishing Composite]	Rec/Stor	e/Packaging Supplier		Other
Root				, <u></u>	Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training					·			•							
Unapproved				<u> </u>				LT CATE	CORV						
Landi						General	AUI	LICATE	JONT	<u></u>					
Landi		Bending				Bend		Grain		-	-	Ovalized		E	Pressure/Forced
	-	Centre No Cracks	ot Concer	ntric to	o/s	BOM/Route Broken/Damaged	-	Hardwa Inspecti	re on Incomplete			Over/Under Part Incorred			Temperature/Cure Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear		Part Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte			-	Part Moved			
	-	Heat Trea				Countersink		Mislabe		<u> </u>		Positioned V	=	_	٦
	Ш	Inspection	n Strip in	Tube	_	Cut Too Short		Misread	!	L		Power Loss/	Surge		Other
•	1	Rinnles in	Rend		- 1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

										DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-	CONF	ORN	MANCE / UP				
								·		QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order.	•		_ _		Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part No	o				Scrap]	ſ	Machining	Small Fab	†	d. Eng. Coor.	Quality
					Use-as-is] T		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No).	···			Work Order Update	J		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initi	al	Ac	tion	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other	_											
Process	┨.											
Supplier												
Training	_											
Unapproved												
						AULT C	ATE	GORY				
Landing	Gear				General					1		1 .
	Bending			1	Bend	Gr	ain			Ovalized		Pressure/Forced

Bending	Bena	Grain	OvalizedPressure/Forced
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperature/Cure
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld
Crushed/Crimped.	Burrs .	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock Pulled
Cuffs	Contamination	Maintenance	Part Moved
Heat Treat	Countersink	Mislabeled	Positioned Wrong
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
Ripples in Bend	Drill Holes	Offset	
Torque Waves in Extrusion	Drawing	Out of Calibration	
Turning Sequence	Finish	Out of Sequence	
Wave/Twist in Tube	Folio	Outside Dimensions	

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Picklist Print March-12-13 1:45:													Page
Work Order ID:	98265												
Parent Item:	D2365							Sta	rt Date: 3/11/1	3	Required l	Date: 3/19	/13
Parent Item Name:	Wearplate							Sta	art Qty: 20.00		Required	Qty: 20.0	0
Comments:	IPP Rev A (IPP Rev:B	Removed from 9 Dig Now On Waterjet	,	5-12-05 JLM -04-04 JLM	Verified By	r:EC					•		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF		Purchased	No			100	Each 2	00000	2	40	5/1	h 7 /2	′
PEM Insert M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			150	16020	2 92. 0625	0.0047	0.098	048	28	
		·		Location		Loc Oty	Lo	c Code					
				MAT021 1231 1240 //3		292.0625 120.5625 171.5 y O. 3							

									DQA:	Date:	
NCR: Y	res / No				WORK ORDER NON-C	CONFOR	RMANCE / UI	PDATE	QA Closed:	 Date:	
 					DISPOSITION	<u> </u>		AGAINST DE		· · · · · · · · · · · · · · · · · · ·	
Work Orde	er:				DISPOSITION	_		AGAINST DE	PARTIVIENT,	/PROCE33	_
Part N					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCIVI					Work Order opdate)	Edige (db	composite	j		
Root				Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		1									
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
					F	AULT CAT	EGORY				
Landir	ng Gear				General				-	_	7
	Bending				Bend	Grain	l		Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (D/S	BOM/Route	Hardv	vare		Over/Under	tolerance	Temperature/Cure
<u> </u>	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
į	Crushed/	Crimped.			Burrs	Instru	ctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Trea	it			Countersink	Mislal	oeled		Positioned V	Vrong	· ·
[Inspection	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
[Ripples in	Bend			Drill Holes	Offset		_			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98265
Description: Wear Plate	Part Number:	D2365
Inspection Dwg: D2365 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.247	/		JKM01	
1.000	+/-0.010	L	/			
0.625	+/-0.010	0-675	/			
0.250	+/-0.010	0.248	/			
0.500	+/-0.010	0.496	/			
R0.125	+/-0.010	0.125	1			
Ø0.290	+0.006/-0.001	0.795	~			
Ø0.191	+0.005/-0.001	0.193	/			
						All and
						,
					-	
			-			
						· · · ·

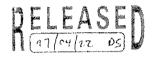
Measured by:	El	Audited by:	09	Prototype Approval:	N/A
Date:	136-28	Date: 2	5.06.23	Date:	N/A

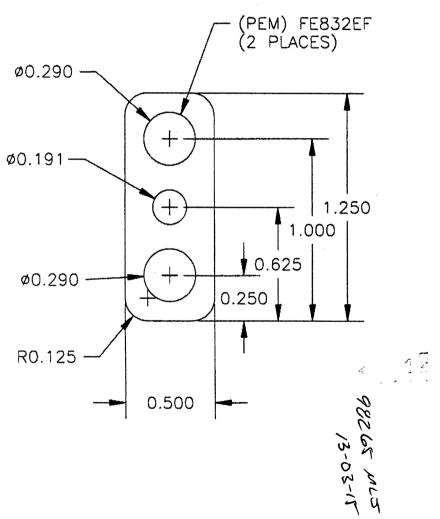
Rev	Date	Change		Revised by	Approved
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM 1,0	
В	08.10.09	Dimensions revise	d	KJ/DD 🛠	78

		•



	DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTE VICTORIA INTERNATIONAL AIRPORT, CANADA	
ı	CHECKED	APPROVED	DRAWING NO.	REV. C
	BW	1	D2365 SHEE	T 1 OF 1
-	DATE		TITLE	SCALE
	95:01:20		WEAR PLATE	2:1
	С	95:03:06	0.191 WAS 0.197	





6061-76 (00-A-250/11) 0.063 THICK 7 \$ 00.09.26
ACID ETGL & ALODINE PER OST OOS 4.1-1) &
INSTITUTE FERSZEF (2 PLS) AFTER ALODINE ALODINE

-AK-30+ 1316-55

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES

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